

Work Order ID 55235

January 12, 2010 1:31:00 PM



Page 1

Item ID: D4050-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 1/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-1-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4050

PAY 2

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch per Dwg. D4050 and Spec Control Dwg D2638

15.69 8 10/01/21 (1)

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr

CF 10/01/21 (1)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> Solutzi

(1)

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 1/12/10

Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/10

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

M113170

0.00

0.00

⇒ JU

10-01-21

(X1)

✓

Memo

START TIME: 12:45pm
OVEN TEMPERATURE: 400°F
FINISH TIME: 1:15pm

140



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 10-01-21

①

φ

150



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 55235

January 12, 2010 1:31:00 PM



Page 3

Item ID: D4050-3

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Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 1/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Prototype test 10.01.30

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

W 1002.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 12, 2010 1:31:05 PM

Work Order ID: 55235



Parent Item: D4050-3



Parent Item Name: Strut

Start Date: 1/12/10

Required Date: 1/25/10

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	326.9924	1.3061			



304 RD Tube .750 x .049W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	326.9924	
107518	2.77	
108498	0	
109314	8.5	
110113	0.73	
110271	0.03	
111096	9	
111457	11.43	
112652	85.89	
112800	208.6424	

1.3061 88 10/01/21 ①

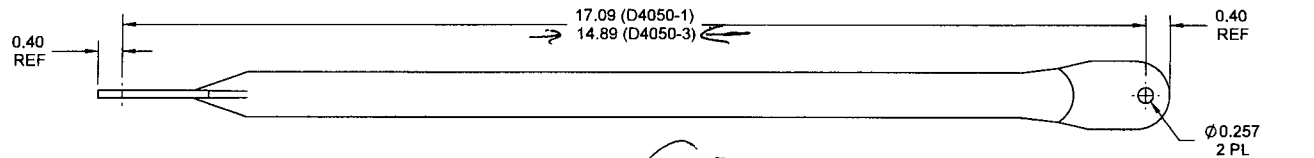
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

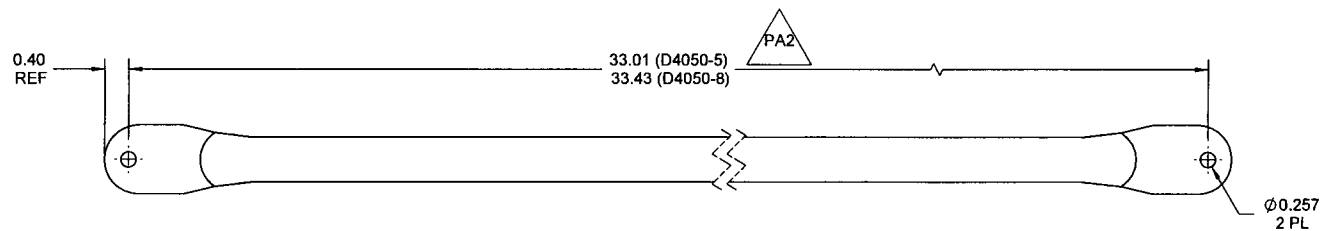
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NOTE: Date & initial all entries



8 D4050-1/-3 STRUT



8 D4050-5/-8 STRUT

W/O 55235

PRELIMINARY ISSUE

10.01.18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS TUBE $\phi 0.750 \times 0.049$ WALL
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4050-1: 0.55 lbs
D4050-3: 0.48 lbs
D4050-5: 1.04 lbs
D4050-8: 1.06 lbs
- 8) PUNCH BOTH END PER SPEC CONTROL DRAWING D2638

PA2	33.01 WAS 31.18; ADD D4050-8 (ZN C4-1)	RF	10.01.18
PA1	NEW ISSUE	RF	09.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4050	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STRUT	NTS
DATE	10.01.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	